

Work Order ID 86029

June-19-12 4:06:30 PM

86029

Page 1

Item ID: D3264-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 19/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3264	Rev A

100

0.00

100

Bandsaw

Memo

0.00

ok 12/06/24

2

Jeaspa Bandsaw

CUT BLANK 5.700" LONG

110

0.00

110

HAAS I

Memo

0.00

ok 12/06/25

8

HAAS CNC vertical machine #1

MACHINE AS PER FOILIO FA447

FOILIO REV: AA

DWG REV: AA

DEBURR AS PER DWG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

ent 12/06/25

QC

Memo

0.00

8

Quality Control

130

QC8- Inspect parts - second check

0.00

130

SL 12-06-25

QC

Memo

0.00

8

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

8 12-6-27

HandFinish

Memo

0.00

Hand Finishing

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Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per OSI005.4.3 Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: **198A**

0.00

170

Packaging

Memo

0.00

Packaging

8 0 12-6-27

8 0 11/06/28

8 12-6-28 50

W/O:		WORK ORDER CHANGES					
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Work Order ID 86029

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86029

Page 4

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Start Date: 19/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/7/3

MF
12-06-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-19-12 4:06:34 PM

Page 1

Work Order ID: 86029

86029

Parent Item: D3264-1

D3264-1

Parent Item Name: Bracket

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A04.09.02New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No				f	8.2417		4			

M6061T6B1 250X04 500

**

6061-T6 Bar 1.25 X 4.50

Location

Loc Qty

Loc Code

MAT004

8.2417

112628

0.7417

121380

7.5

4 on 12/06/24

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	86029
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.689	—		Vern HL-06	
0.063	+/-0.010	0.063	—		"	
0.125	+/-0.010	0.125	—		"	
0.875	+0.010/-0.020	0.878	—		"	
0.062	+/-0.010	0.062	—		"	
R0.03	+/-0.030	R.030	—		R-G	
R0.13	+/-0.030	R.125	—		"	
1.00	+/-0.030	1.004	—		Vern HL-06	
0.125	+/-0.010	0.127	—		"	
0.600	+/-0.010	0.600	—		"	
4.000	+/-0.005	4.000	—		"	
0.750	+/-0.010	0.749	—		"	
Ø0.194	+0.005/-0.000	Ø0.195	—		"	
5.50	+/-0.030	5.500	—		"	
0.125	+/-0.010	0.127	—		"	
0.063	+/-0.010	0.062	—		"	
R0.25	+/-0.030	R.250	—		R-G	
4.27	+/-0.030	4.270	—		Vern HL-06	
R0.30	+/-0.030	R.300	—		R-G	

Measured by:	<i>AK</i>	Audited by:	<i>SL</i>	Prototype Approval:	N/A
Date:	12/06/25	Date:	12-06-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	<i>AK</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

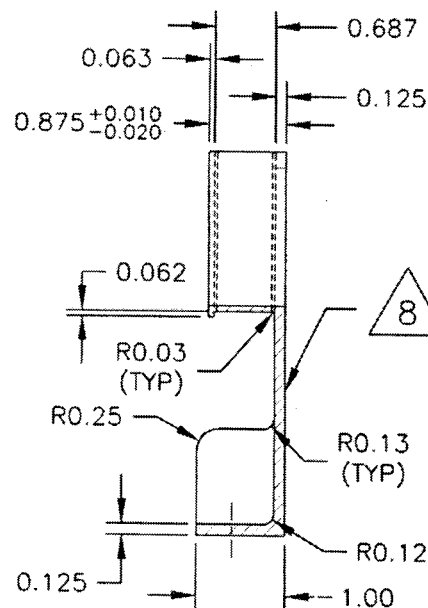
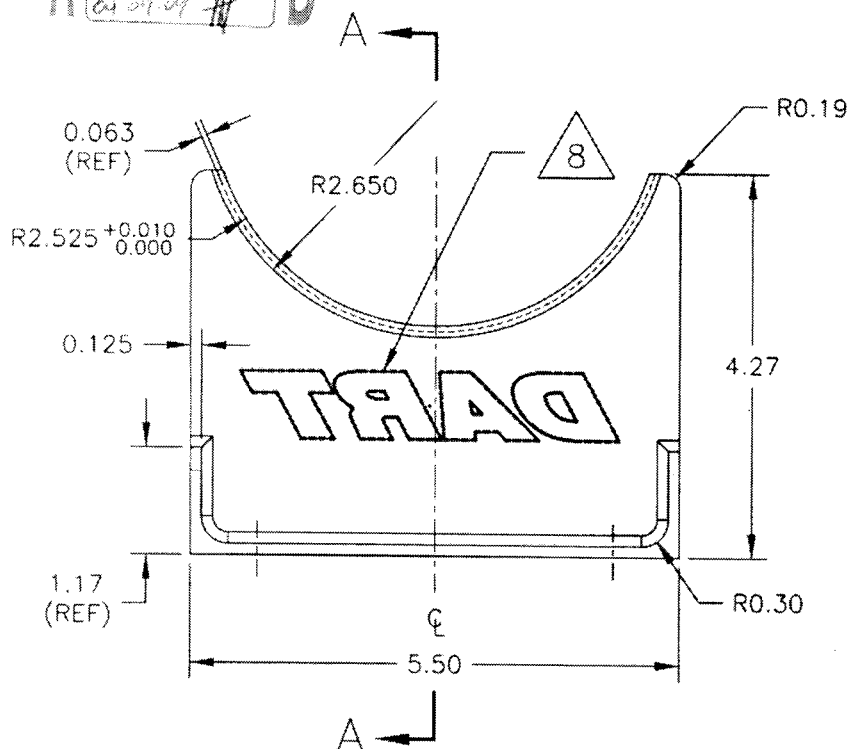
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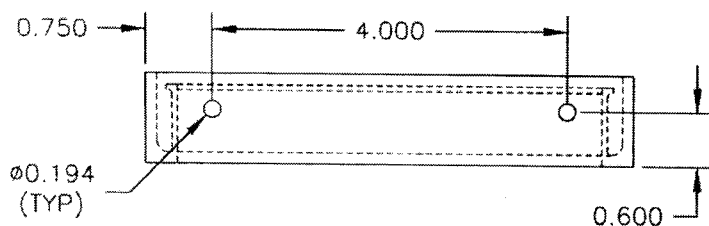


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.04.20



SECTION A-A



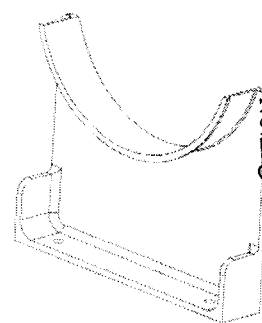
D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT 7/06/12/18
WITHOUT NOTICE
WORK ORDER
NO. 60025 MJS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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